

Date: Tuesday, 4/25/2006 7:35:10 AM
User: Kim Johnston

Process Sheet

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: Oct 15/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 26786B

Part Number: D2658

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/26

Job Completion



U 06/05/26

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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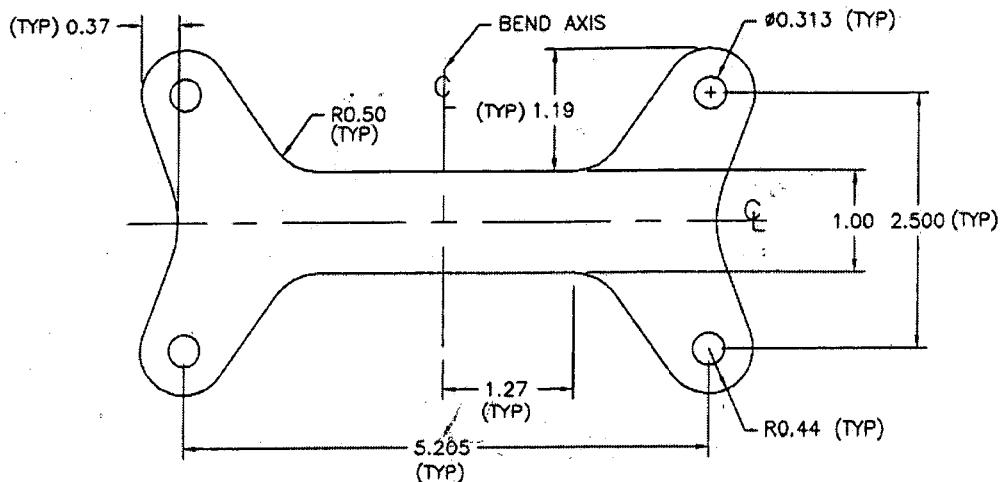
NOTE: Date & initial all entries

DART

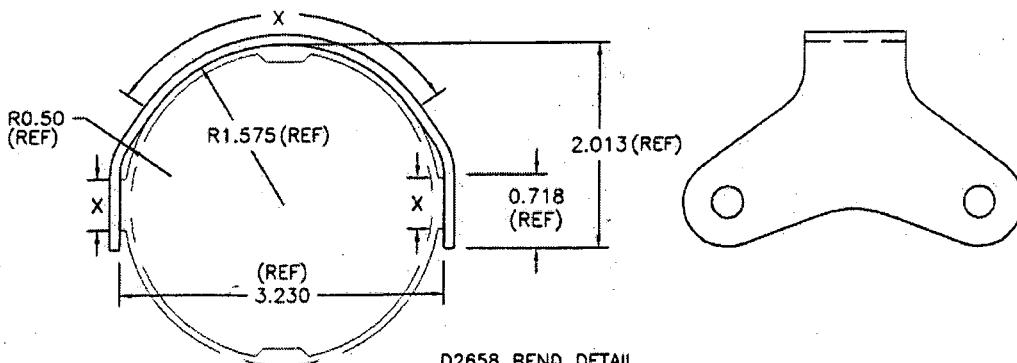
5 COPY ISSUED

RELEASED
98.12.14 DS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
<i>CP</i>	<i>KE</i>	D2658	SHEET 1 OF 1
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26786B

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



P60124PC001

Shanxi Taihang Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD
NO.2 jiancaoping,Taiyuan,Shanxi,P.R.China
TEL: (0351)301328 FAX: (0351)3017816
<http://www.tisco.com.cn>
E-mail: tgbxg@tisco.com.cn

MILL TEST CERTIFICATE

MATERIAL	AISI304 No.2B Finish
SPECIFICATION	ASTM A240/A480
L/C NO.	ASME SA240/SA480
CERTIFICATE NO.	20051187
DATE OF ISSUE	/ /

CUSTOMER CONTRACT NO.: 1187 DATA OF
OLBERT 2005/11/30

Product	Melting furnace	Inspector's stamp	Mark of the Manufacturer	
			E+VOD	Shanxi Taiyuan Stainless Steel Co.,ltd
COIL				
NO.	Heat No.	Coil No.	Quantity	Dimensions
8.	4505286	SA9-495-1ZD	1	11GA × 48 × C
9.	Y506019	SA9-485-1ZB	1	11GA × 48 × C
10	4505044	SA9-458-1ZY	1	14GA × 48 × C
11	4505274	SA9-450-1ZD	1	11GA × 48 × C
12	4505271	SA10-44-5ZJ	1	16GA × 48 × C
13	4505050	SA10-53-1ZJ	1	16GA × 48 × C
14	4505393	SA10-70-4ZY	1	14GA × 48 × C

Chemical Composition											
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4505286	0.060	0.470	1.400	0.017	0.003	18.170	8.920	0.010	0.010	0.010	0.055
Y506019	0.050	0.350	0.990	0.032	0.004	18.300	8.090	0.440	0.006	0.120	0.070
4505044	0.060	0.450	1.370	0.018	0.002	18.200	8.120	0.010	0.010	0.010	0.050
4505274	0.060	0.520	1.320	0.017	0.003	18.150	8.120	0.010	0.010	0.010	0.045
4505271	0.060	0.470	1.320	0.016	0.003	18.170	8.110	0.010	0.010	0.010	0.045
4505050	0.050	0.480	1.290	0.014	0.002	18.230	8.060	0.010	0.010	0.010	0.040
4505393	0.070	0.480	1.260	0.017	0.002	18.200	8.070	0.010	0.010	0.010	0.040

Test No.	Tensile Rm N/mm ²	R _{0.2} Yield _{0.2%} N/mm ²	R _{p0.5} Yield _{0.5%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
4505286-T	635	282		55		84 - 83		
Y506019-T	650	266		53		88		
4505044-T	675	307		59		83 - 83		
4505274-T	690	299		56		86 - 85		
4505271-T	700	326		54			182 - 186	
4505050-T	695	297		57			190 - 188	
4505393-T	680	295		60		85 - 85		

Surface and dimensions controlled:

Work Inspected



Page 2 of 3

P60124PC001V 3042B .062X48 HT 4505271 4505050

